

Date: Wednesday, 03/09/2008 10:26:12 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE				
<b>Job Number</b>	: 41725							
<b>Estimate Number</b>	: 12930							
<b>P.O. Number</b>	:			<b>Part Number</b>	: D29322UP			
<b>This Issue</b>	: 03/09/2008	S.O. No. :		<b>Drawing Number</b>	: D2932 REV C			
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A			
<b>First Issue</b>	: / /	Type :		<b>Drawing Revision</b>	: C			
<b>Previous Run</b>	: 35227			<b>Material</b>	:			
<b>Written By</b>	:			<b>Due Date</b>	: 26/09/2008			
<b>Checked &amp; Approved By</b>	: JLD 08.8.03			<b>Qty:</b>	2	<b>Um:</b> Each		
<b>Comment</b>	: Est Rev:A New Issue 07-07-04 JLM							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: 34873	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 41725

Part Number: D29322UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	J-L 08/09/12  (2x)
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 444	FZ 08/09/12 (2)  (2x) 6/9/12 SC
9.0	QC21	FINAL INSPECTION/W/O RELEASE 
	Comment: FINAL INSPECTION/W/O RELEASE	08/09/15  MF 08-09-12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41725
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.130				
B	0.100	0.140		.130	.130				
C	0.100	0.140		.127	.127				
D	0.210	0.230		.223	.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.110	.110				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.480	2.480				
S	0.240	0.270		.250	.260				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.321	.321				
X	1.125	1.145		1.131	1.131				
Y	1.565	1.585		1.570	1.570				
Z	0.178	0.198		.185	.185				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
<b>Accept/Reject</b>									

Measured by:	<i>RF</i>	Audited by:	<i>J-L</i>
Date:	<i>08/09/11</i>	Date:	<i>08/09/12</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>RF</i>	<i>RF</i>

